

Work Order ID 92596

92596

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November-01-12 1:12:03 PM

Item ID: D2739

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 350 I Beam

Start Date: 01/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-11-01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

Dec 12/11/14

4 RLB 12/12

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

4 0 12-11-14 DAS 18 9-89

140

Identify as per dwg & Stock Location: LG

0.00

140

Packaging

Memo

0.00

Packaging

4 0 12-11-14

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/11/15 MP 12-11-14

Picklist Print

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Work Order ID: 92596

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Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 01/11/2012

Required Date: 15/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-080

Manufactured No

Each 165.0000

4

D2600-5-080

**

Dec 12 / 11 / 12

Extrusion 'I Beam' thin

Location

Loc Qty

Loc Code

LG

165

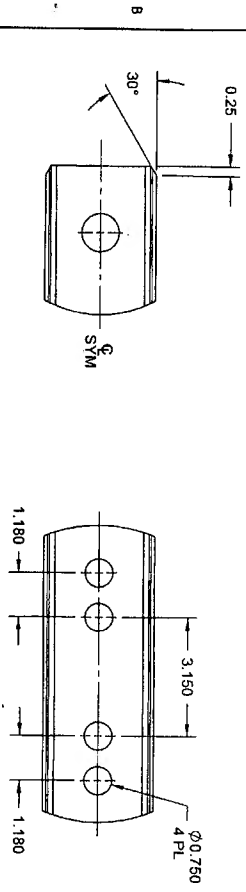
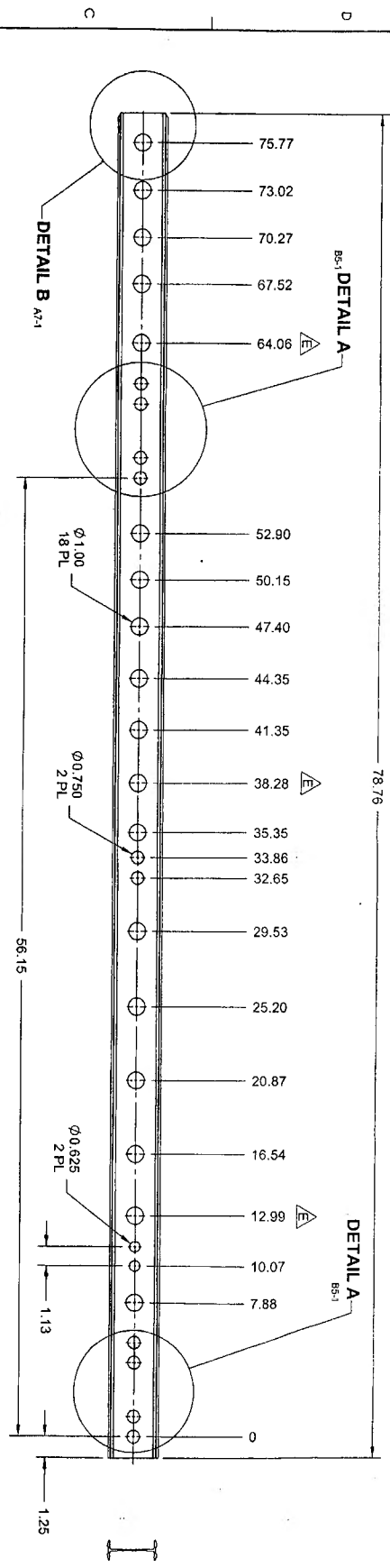
73867

1

90683

164

4



DETAIL B
SCALE 3X

DETAIL A
SCALE 3X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005.4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART PIN "D2739" AND BIN PER DART OSI 044.6.1
 - 7) WEIGHT: 3.41 lbs

SHC 011
RETURNED
UNCONTROLLED
SUBJECT TO AMENDMENT
WORK CENTER
NO. 92596 M/S
12-11-01

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DS	98.04.16
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAFTER	CP	98.11.18
C	ADD BEVEL TO FWD END; ADD DETAIL B	PH	08.01.05
D	ADD BEVEL TO FWD END; ADD DETAIL B	DB	07.05.29
E	ADD MOVE HOLES FOR D2154 WEARPLATE; 38.28 WAS 38.35 (DS-1); 64.00 WAS 64.17 (DS-1); ADD HOLE (DS-1)	CP	10.10.08

DESIGN	DS	DESCRIPTION	DART AEROSPACE USA, INC.
DRAWN	DS	DRAWING NO.	PORT HADLOCK, WA
CHECKED	DS		
MFG. APPR.	DS		
APPROVED	DS	TITLE	D2739
DE APPR.	DS		
DATE	10.10.08	WEB	

RELEASED
2010-11-01

